

Work Order ID 62828

Friday, October 08, 2010 12:48:36 PM



Page 1

Item ID: D3685-041

Accept



Setup Start



Revision ID:

Stop



Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 10/8/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 2.00



Customer:

Reference:

10-14-08

Approvals:

Process Plan:

Date: 10-14-08

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3685

Rev D

100

Pick Kit

0.00



Packaging

Memo

0.00

SS 11/04/04

(2)

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

(2)

Small Fab

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3685

2-Assemble D3684-047 & D3687-3 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3685

***Ensure holes for AN3C Bolts are free of sealant.

Torque Fastners as per Dwg D3685

SS 11/04/04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 11/04/104

22

130

Identify as per dwg & Stock Location: 17

0.00



Packaging

Memo

0.00

Packaging

11/4/15 200

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/15 200

11/04/05

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Picklist Print

Friday, October 08, 2010 12:48:40 PM

Page 1

Work Order ID: 62828

Parent Item: D3685-041

Parent Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:LL
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN3C12A Bolts		Purchased	No			110	Each	50.0000	4	8			
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Location	Loc Qty	Loc Code
ST351	50	M 116924
112314	8	
114761	11	
115392	11	
115594	20	

D3684-047 FWD LEG ASS'Y		Manufactured	No			110	Each	0.0000	1	2			
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D3684-049 AFT LEG ASS'Y		Manufactured	No			110	Each	0.0000	1	2			
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D3687-3 MOUNT		Manufactured	No			110	Each	4.0000	1	2			
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Location	Loc Qty	Loc Code
ST075	4	
61964	4	
B 61890		

2

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Parent Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 2.00

Required Qty: 2.00

D3692-1

Manufactured No

110

Each

305.0000

8

16



SPACER



SB 11/04/04

Location

Loc Qty

Loc Code

ST082

305

51467

305

~~16~~ 16

MS21043-3

Purchased No

110

Each

2,579.000

4

8



SB 11/04/04

Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2503

111383

38

112314

2465

~~8~~ 8

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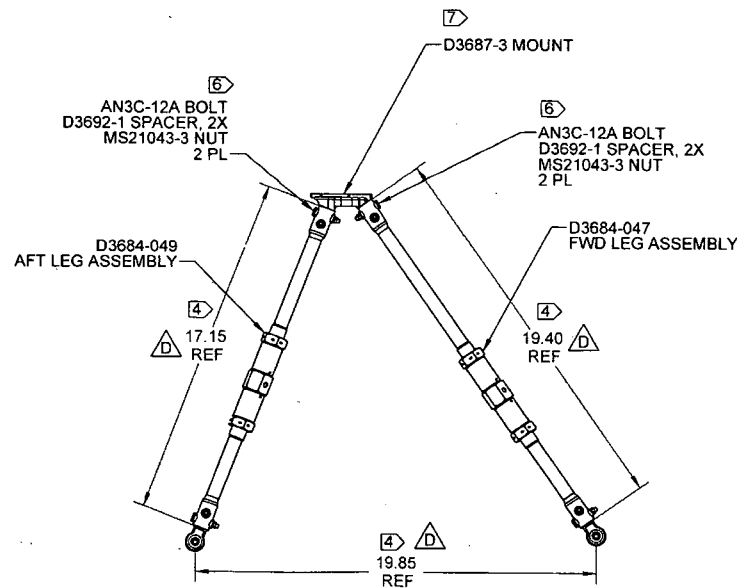
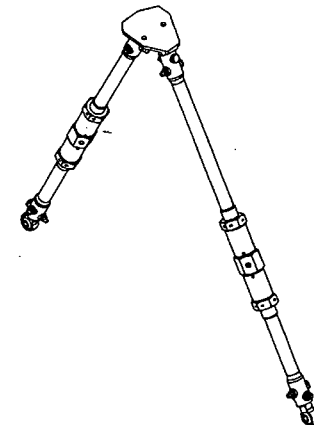
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SHOP COPY

ENGINEER
UNCONTROLLED
SUBJECT

NO. 42825
P810-10-8



D3685-041 BIPOD MOUNT ASSEMBLY

RELEASED
2010-03-15
NP

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3685-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-3 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

D	17.15 WAS 17.27 (ZN B6-1); 19.40 WAS 19.52 (ZN B4-1); 19.85 WAS 20.24 (ZN B5-1)	RF	10.03.03
C	NOW ASSEMBLED USING SEALANT (ZN A8-1, C4-1)	RF	08.12.15
B	19.52 WAS 19.95 (ZN B4-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3685 TITLE BIPOD MOUNT ASSEMBLY SCALE NTS <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF	DATE 10.03.03	

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